
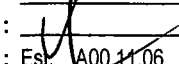


Date: Thursday, 24/08/2006 8:24:33 AM  
 User: Linda Lacelle











## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STA 155 BRACKET
<b>Job Number</b> : 28310	
<b>Estimate Number</b> : 11040	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D28042
<b>This Issue</b> : 24/08/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2804 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28302	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 31/08/2006 <b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
		
<b>Comment:</b> Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50" Batch: <u>M10263</u> <u>SAD 06:08:14</u>		
2.0	WATER JET	FLOW WATER JET
		
<b>Comment:</b> FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>SAD 06:08:14</u> 8		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103 <u>J.L 06/08/25</u> 8		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>J.L 06/08/25</u> 8		
5.0	QC8	SECOND CHECK
		
<b>Comment:</b> SECOND CHECK <u>MS 06/08/25</u> 8		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: DP Date: 06/09/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/08/2006 8:24:33 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 155 BRACKET

Job Number: 28310

Part Number: D28042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Tumble & Deburr

Er 06/08/29, X 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0608-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

DL 06/08/29 (8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: ST469

LB 9/8/31 (8)  
06/08/31 (8)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

06/09/01 (8)

Job Completion



u 06-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

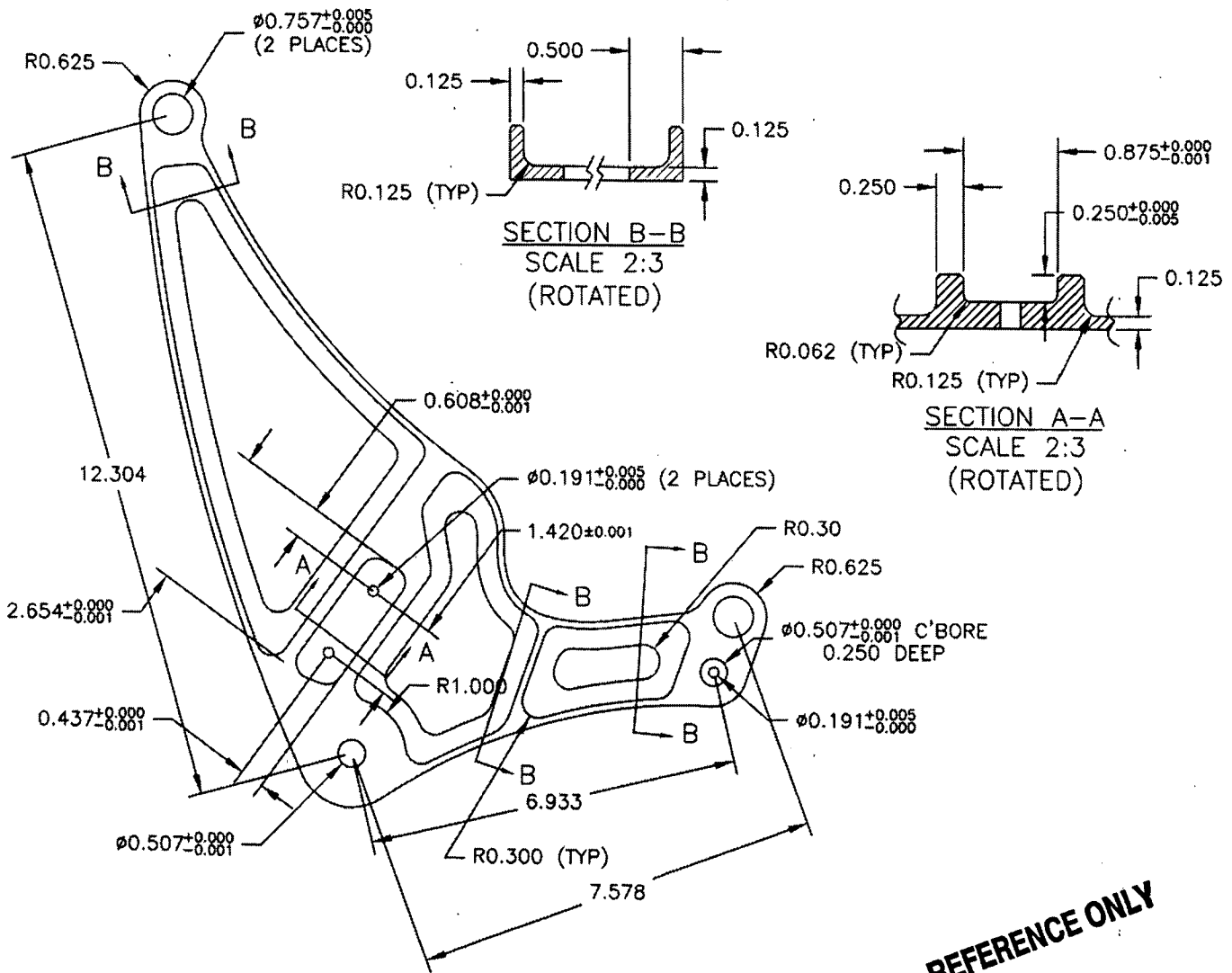
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE	04.11.22		TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07		NEW ISSUE		
B	04.11.22		ADD CUTOUTS & -043/-044		

**RELEASED**05-03-11 *[Signature]***D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

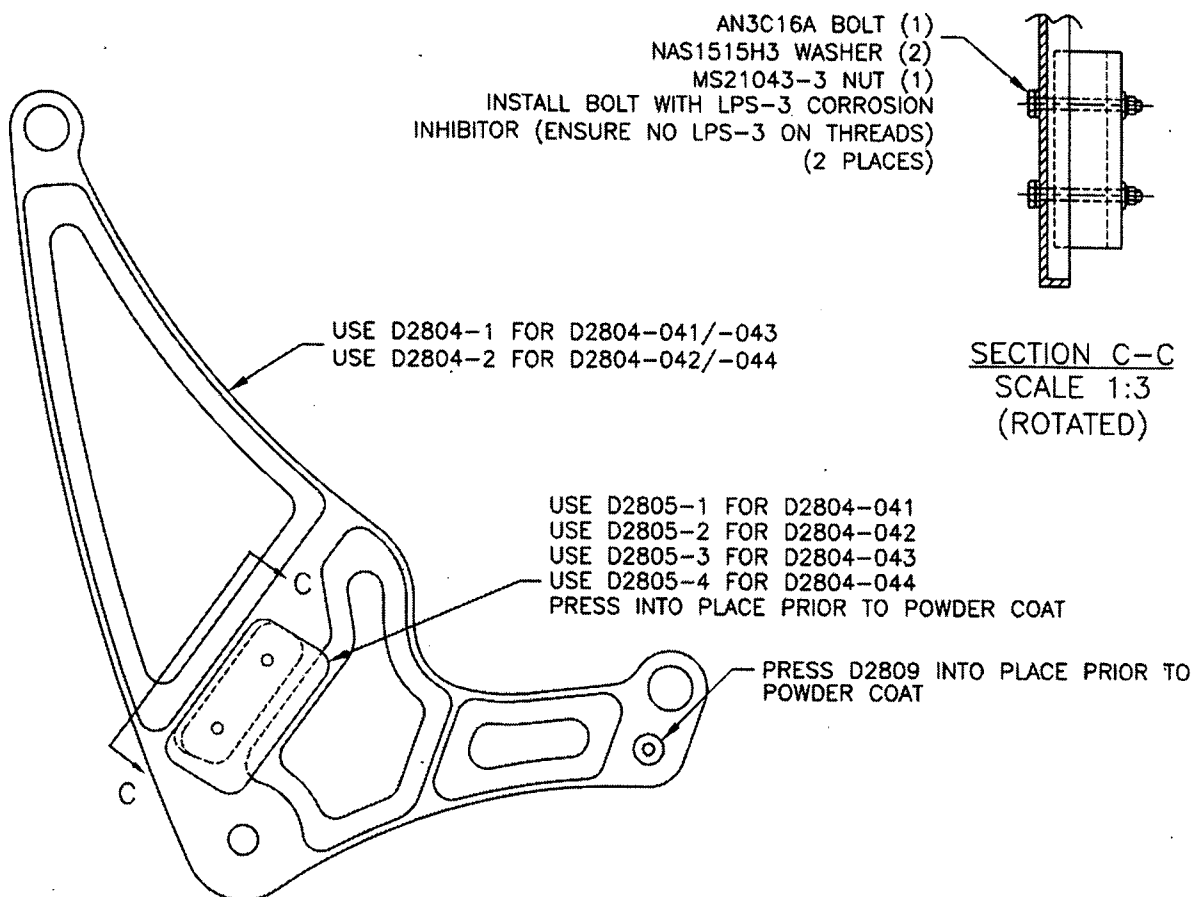
- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
CP	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D2804	SHEET 2 OF 2
DATE	TITLE		SCALE
04.11.22	STA 155 BRACKET		1:3



**REFERENCE ONLY**  
**RELEASED**

05-03-11 *[Signature]*

**D2804-041/-043 BRACKET ASS'Y (SHOWN)**  
**D2804-042/-044 BRACKET ASS'Y (OPPOSITE)**

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)  
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 28310
<b>Description:</b> STA 155 Bracket		<b>Part Number:</b> D2804-2
<b>Inspection Dwg:</b> D2804	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.128	✓			
R0.125	+/-0.010	.125	✓			
0.250	+/-0.010	.249	✓			
0.250	+0.000/-0.005	.247	✓			
0.875	+0.000/-0.001	.8745	✓			
R0.062	+/-0.010	.062	✓			
Ø0.757	+0.005/-0.000	.759	✓			
R0.625	+/-0.010	.625	✓			
12.304	+/-0.005	12.303	✓			
Ø0.507	+0.000/-0.001	.5065	✓			
0.437	+0.000/-0.001		can't measure			
0.608	+0.000/-0.001		"			
Ø0.191	+0.005/-0.000	.193	✓			
1.420	+0.001/-0.001	.1420	✓			
0.250 deep	+/-0.010	.251				
6.933	+/-0.005	6.933	✓			
7.578	+/-0.005	7.577	✓			
0.500	+/-0.010	.503	✓			

<b>Measured by:</b> J.L.	<b>Audited by:</b> Jm	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/08/24	<b>Date:</b> 06/08/25	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	